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D4895-045
Job Sheet 183261



Part No: D4895-045

Job Qty: 1 ea

Part Name: Fwd Outboard Beam Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/14/18

Job Tracking No:

Due Date: 10/5/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP REV:A 14.07.25 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	1 Ea	10/5/18	10/5/18	0.00	0.00	Start Up Waterjet		on 18/09/27
100	Waterjet	1 pcs	10/5/18	10/5/18	0.00	0.84	Waterjet1		on 18/09/27
110	CNC Vertical Machining	1 pcs	10/5/18	10/5/18	1.13	3.33	HAAS1-5		Kt 2018-10-12
120	QC	1 pcs	10/5/18	10/5/18	0.00	0.00	QC2 Machining-3		Kt 2018-10-12
150	QC	1 pcs	10/5/18	10/5/18	0.00	0.00	QC8 Machining-3		marc 18/10/12
160	HandFinish	1 pcs	10/5/18	10/5/18	0.00	0.24	HandFinish1		D.B 18/10/15
170	QC	1 pcs	10/5/18	10/5/18	0.00	0.00	QC7-4		DE 18-10-15
171	Powdercoat	1 pcs	10/5/18	10/5/18	0.00	0.12	Powdercoat1		DE 18-10-15
172	QC	1 pcs	10/5/18	10/5/18	0.00	0.00	QC3		OCT 17 2018 68
180	Small Fab	1 pcs	10/5/18	10/5/18	0.00	0.19	Small Fab-8		9-89
190	QC	1 pcs	10/5/18	10/5/18	0.00	0.00	QC5		OCT 17 2018 68
200	Packaging	1 pcs	10/5/18	10/5/18	0.00	0.00	Packaging3-2		OCT 17 2018 9-89
210	QC21-SA	1 Ea	10/5/18	10/5/18	0.00	0.00	QC21		9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X12.000	6061-T6 Bar 1.00 X 12.00	3.0100 ft (3.01 ea)	90-Start up Operation	
D4859-1	Bushing	4 Ea (4 ea)	180-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X12.000	3	14	0
180-Small Fab	D4859-1	4	7	0

5083983

START: 11:20

TECH: 3200

FINISH: 11:50

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

DART AEROSPACE LTD		Work Order:	183261
Description: Fwd Outboard Beam		Part Number:	D4895-5
Inspection Dwg: D4895	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC Milling	32.55	+/-0.030	32.55	✓			
	R0.38	+/-0.030	0.38	✓			
	0.85	+/-0.030	0.85	✓			
	0.93	+/-0.030	0.930	✓			
	8.32	+/-0.030	8.32	✓			
	Ø0.425	+0.000/-0.002	0.423	✓			
	0.750	+/-0.010	0.750	✓			
	0.200	+/-0.010	0.200	✓			
	R0.43	+/-0.030	0.43	✓			
	3.00	+/-0.030	3.00	✓			
	3.50	+/-0.030	3.500	✓			
	0.15	+/-0.030	0.157	✓			
	0.250	+/-0.010	0.250	✓			
	5.75	+/-0.030	5.75	✓			
	1.34	+/-0.030	1.34	✓			
	1.00	+/-0.030	1.00	✓			
	R0.13	+/-0.030	0.135	✓			
	0.150	+/-0.010	0.150	✓			
	1.15	+/-0.030	1.15	✓			
	3.00	+/-0.030	3.00	✓			
	Ø0.377	+0.006/-0.001	0.377	✓			
	3.50	+/-0.030	3.500	✓			
	1.75	+/-0.030	1.75	✓			
	3.600	+/-0.005	3.600	✓			
	1.800	+/-0.005	1.800	✓			
	0.80	+/-0.030	0.800	✓			
	0.60	+/-0.030	0.600	✓			
	2.300	+/-0.005	2.300	✓			
	Ø1.00	+/-0.030	1.00	✓			
Manual Mill	0.25	+/-0.030	0.250	✓			
	5.50	+/-0.030	5.50	✓			
	12.000	+/-0.005	12.000	✓			
	1.55	+/-0.030	1.55	✓			
	Ø0.465 X 90°	+/-0.010 x 0.5°	0.465 x 90°	✓			
	R0.25	+/-0.030	0.250	✓			
	0.500	+/-0.010	0.500				

Measured by: kt	Audited by: gmm	Preliminary Approval:
Date: 2010-10-12	Date: 10/10/12	Date:

Rev	Date	Change	Revised by	Approved
A	14.08.05	New Issue	KJ	

UAK!

AEROSPACE

Container No: S114238

Part: D4895-045

Job No: 183261

Serial No/Batch: S114238

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 09/27/18